

Having thus described the invention, what is claimed is:

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1. A method of forming and filling reclosable plastic bags comprising the steps of:
continuously advancing a base film of plastic bag making material horizontally in a longitudinal direction of said base film;
loading product in first and second longitudinally extending lines onto said base film at spaced apart bag length intervals, the products on said lines being disposed in transversely aligned rows;
applying first and second slider operated zippers onto said base film between said lines of product, each of said zippers comprising first and second profiles having mating interlocking portions;
applying a cover film of plastic bag making material over said base film covering said lines of product and said zippers, said cover film being joined to said base film along longitudinally extending lines disposed on sides of said product opposite to said two zippers;
joining the first profile of each of said first and second zippers to said base film and joining the second profile of each of said first and second zippers to said cover film;
longitudinally joining said base film to said cover film between said first and second zippers ;
sealing said base film to said cover film along transverse seal sections on opposite sides of each row of product, said transverse seal sections extending between said longitudinally extending lines joining said base film to said cover film;
longitudinally cutting through said base film between said two zippers; and

cutting through said transverse seal sections to release filled reclosable bags.

2. The method in accordance with claim 1 wherein said base film is sealed to said cover film simultaneously with said zipper profiles being sealed to said base and cover film.
3. The method in accordance with claim 1 comprising the further step of joining said base film to said cover film with a peel seals between each of zippers' mating interlocking portions and said longitudinally extending lines of products.
4. The method in accordance with claim 1 comprising the further step of forming longitudinally extending lines of weakness between the locations at which said base film is longitudinally joined to said cover film and the locations where said zipper profiles are joined to said base and cover films.
5. The method in accordance with claim 1 wherein said transverse seal sections are cut as said base film is sealed to said cover film.
6. The method in accordance with claim 1 comprising the further step of shaping said first and second zippers at bag width intervals to form slider stops and positioning a slider between each pair of stops.

7. The method in accordance with claim 6 wherein said first and second zippers are applied to said base film with each of said stops aligned with said transverse seal sections.

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8. The method in accordance with claim 1 wherein said first zipper first profile includes a flange, said second zipper first profile includes a flange joined to said first zipper first profile flange and said first and second zippers are attached to said base film by sealing said joined flanges to said base film.

9. The method in accordance with claim 1 wherein said base film and said cover film are separately supplied and said base film is sealed to said cover film along said longitudinally extending lines disposed on sides of said product opposite to said zippers.

10. The method in accordance with claim 1 wherein said base film comprises a center section of a common film and said cover film comprises side portions of said common film folded over said center section along longitudinally extending fold lines whereby longitudinally extending free edges of said side portions are positioned between said first and second zippers.

11. The method in accordance with claim 10 wherein said cover film is joined to said base film by longitudinally extending peel seals positioned between said free edges and said first and second zipper.

12. An apparatus for forming and filling reclosable plastic bags comprising:
means for horizontally advancing a base film of plastic bag making material continuously in a longitudinal direction of said base film;
means for transversely loading product in first and second longitudinally extending lines onto said base film at spaced apart bag length intervals, the products on said lines being disposed in transversely aligned rows;
means for applying first and second slider operated zippers onto said base film between said lines of product, each of said zippers comprising first and second profiles having mating interlocking portions;
means for applying a cover film of plastic bag making material over said base film covering said lines of product and said zippers, said cover film being joined to said base film along longitudinally extending lines disposed on sides of said product opposite to said two zippers;
means for joining the first profile of each of said first and second zippers to said base film and joining the second profile of each of said first and second zippers to said cover film;
means for sealing said base film to said cover film along transverse seal sections on opposite sides of each row of product, said transverse seal sections extending between said longitudinally extending lines joining said base film to said cover film;
means for longitudinally cutting through said base film between said two zippers;
and
means for cutting through said transverse seal sections to release filled reclosable bags.

13. The apparatus in accordance with claim 12 further comprising means for applying sliders to said first and second zippers disposed upstream of said means for applying said first and second zippers onto said base film.

14. The apparatus in accordance with claim 12 further comprising means for shaping said first and second zippers at bag width intervals to form slider stops wherein said slider applying means positions one of said sliders between each pair of stops.

15. The apparatus in accordance with claim 12 wherein said base film and said cover film are separately supplied and further comprising means for sealing said base film to said cover film along longitudinally extending lines disposed on sides of said product opposite to said zippers.

16. The apparatus in accordance with claim 12 wherein said base film comprises a center section of a common film and said cover film comprises side portions of said common film and further comprising means for folding said side portions over said center section along longitudinally extending fold lines and for guiding longitudinally extending free edges of said side portions between said first and second zippers.

17. The apparatus in accordance with claim 12 further comprising a guide separator between said base and cover film for separating said the first and second profiles of said

first zipper from one another as said profiles are joined to said base film and said cover film.

18. The apparatus in accordance with claim 12 further comprising means for forming longitudinally extending lines of weakness between the locations at which said base film is longitudinally joined to said cover film and the locations where said zipper profiles are joined to said base and cover films.

19. The apparatus in accordance with claim 18 further comprising a first guide separator between said base and cover film for separating the flanges of said the first and second profiles of said first zipper from one another as said profiles are joined to said base film and said cover film; and

second and third guide separators respectively aligned with said means for forming longitudinally extending lines of weakness between the locations at which said base film is longitudinally joined to said cover film and the locations where said zipper profiles are joined to said base and cover films.

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20. The method in accordance with claim 1 wherein said first zipper first profile includes a flange attached to a web, said second zipper first profile includes a flange attached to said web, and said web is sealed to said base film.